

Date: Monday, 1/8/2007 10:25:32 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACER		
Job Number	: 30107		Part Number	: D2213		
Estimate Number	: 10001		Drawing Number	: D2213 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 1/8/2007		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: NA		
First Issue	: N/A		Due Date	: 1/30/2007		
Previous Run	: 30049		Qty:	160	Um:	Each
Written By	: <u>JLM</u>		Comment	: Est Rev: CU turned In-House 05-10-17		
Checked & Approved By	: <u>JLM</u> 07.01.08		Comment	: JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R0750	6061-T6 Round Bar .750" MS 07/01/17
<p>Comment: Qty.: 1.1000 in(s)/Unit Total: 176.0000 in(s) MATERIAL:6061-T6 Round Bar .750" (M6061T6R0750) Batch: <u>103156</u> 13.685 fls) MS 07/01/17</p>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL MS 07/01/17
<p>Comment: HARDINGE CNC LATHE SMALL 1-TURN AS PER FOLIO FA113 & DWG D2213 , FOLIO REV: <u>A</u> DWG REV: <u>B</u></p>		
3.0	QC2	2-DEBURR AS REQUIRED MS 07/01/17 161
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE MS 07/01/17 161</p>		
4.0	QC8	SECOND CHECK J.L 07/01/17
<p>Comment: SECOND CHECK J.L 07/01/17</p>		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 counted 07/01/17(161)
<p>Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 07/01/17(161)</p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/01/18
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SPACER

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

1/7/01/18 (161)

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 29

1/7/01/18 (161)

8.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1/7/01/18

Job Completion



1/7/01/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30109
Description: Spacer	Part Number:	D2213
Inspection Dwg: D2213	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

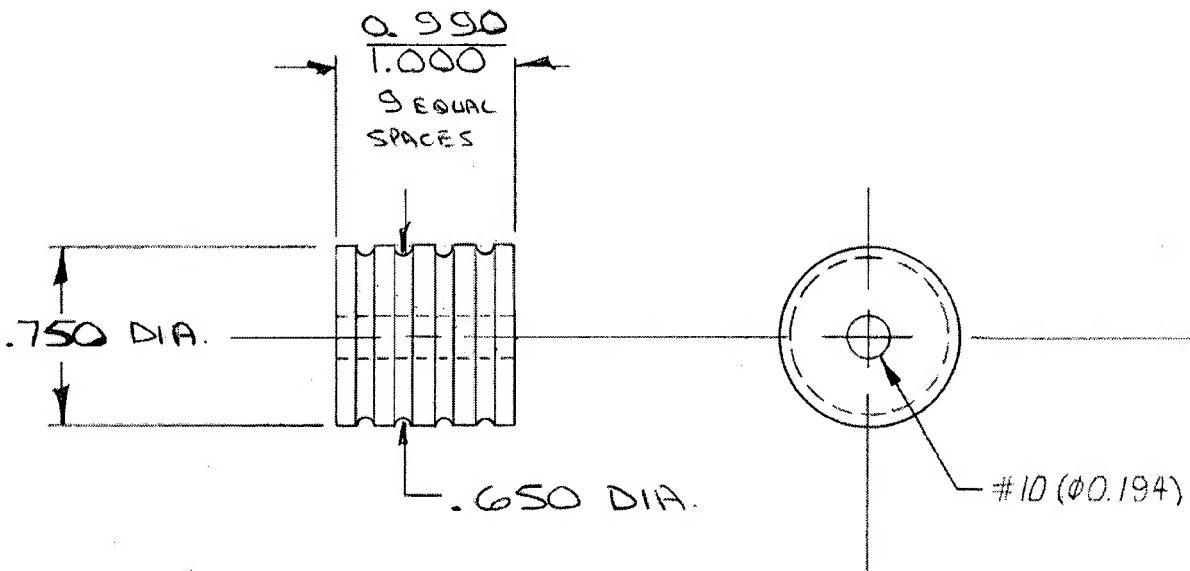
X First Article Prototype

Measured by:	MS	Audited by:	SD	Prototype Approval:	N/A
Date:	07/01/17	Date:	07.01.17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	Jeff

DARTG4 COPY
BRISSIE

DRAWN BRADLEY 94.2. S	DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA
DESIGN BRADLEY 94.2. S	DRAWING NO. D2213 REV. B
STRESS	SHEET 1 OF 1 TITLE SPACER
B 95:08:17	#10 HOLE ADDED

MATERIALALUMINUM ALLOY 2011-T3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30107